

# Work Order ID 62816

Friday, October 08, 2010 12:45:44 PM



Page 1

Item ID: D2344

Accept



Setup Start



Revision ID:

Stop



Item Name: Litter Deck Plate, 350

Start Date: 10/8/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date:

*10/10/08*

Tooling:

Date:

Run Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2344

Rev F

100

0.00



FLOW WATER JET

Waterjet

Memo

*F*  
*F*

0.00

FLOW CNC Waterjet

*2024 063*

*10-10-18*

*(4)*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*10-10-18*

120

0.00



QC8- Inspect parts - second check

QC

Memo

*JH-03*

0.00

Quality Control

*4*

*10/10/19*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Start Date: 10/8/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-Deburr sharp edges □2-Countersink holes per Dwg D2344								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
150 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

*EP 10/10/20* (4)

*SS 10/10/21*

(4)

*=> MU 10/10/22*

*4 9*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 62816

Friday, October 08, 2010 12:45:44 PM



Page 3

Item ID: D2344

Accept



Setup Start



Revision ID:

Stop



Item Name: Litter Deck Plate, 350

Start Date: 10/8/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

10-10-27.

0.00

Memo

START TIME:

320° FINISH TIME:

11:30

OVEN TEMPERATURE:

12:00.

4

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

10/10/27

0.00

Memo

+

Ø

180



Packaging

Packaging

Identify as per dwg & Stock Location: 224

0.00

0.00

Memo

10/10/27 (40) SL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 62816**

Friday, October 08, 2010 12:45:44 PM

Page 4

Item ID: D2344

Accept

Setup Start

Revision ID:

Stop

Item Name: Litter Deck Plate, 350

Start Date: 10/8/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/28  
MF  
10-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Friday, October 08, 2010 12:45:48 PM

Page 1

Work Order ID: 62816

Parent Item: D2344

Parent Item Name: Litter Deck Plate, 350



Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D 00.06.26 Removed P/O for powder coat EC  
IPP Rev:E 07-07-04 Asper Rev F JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.063		Purchased	No			100	sf	104.8000	0.745	3.136842			
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2024-T3 .063 sheet



810-10-18

Location

Loc Qty

Loc Code

MAT22

104.8

113866

15.5

114351

89.3

113866

(4)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	62814
<b>Description:</b> Litter Deck Plate Kit (350)		<b>Part Number:</b>	D2344
<b>Inspection Dwg:</b> D2344 <b>Rev:</b> F		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.223	+/-0.010	6.221	X		V 1802	
5.598	+/-0.010	5.598	X		V	
4.869	+/-0.010	4.869	X		V	
3.889	+/-0.010	3.887	X		V	
3.096	+/-0.010	3.094	X		V	
2.891	+/-0.010	2.891	X		V	
16.973	+/-0.010	16.973	X		V 1801	
0.450	+/-0.010	0.444	X		V	
4.423	+/-0.010	4.421	X		V	
4.723	+/-0.010	4.717	X		V	
1.202	+/-0.010	1.197	X		V	
5.869	+/-0.010	5.867	X		V	
4.654	+/-0.010	4.654	X		V	
Ø0.656	+0.005/-0.000	0.657	X		V	
1.888	+/-0.010	1.885	X		V	
2.285	+/-0.010	2.283	X		V	
2.683	+/-0.010	2.684	X		V	
Ø0.171	+0.005/-0.000	0.173	X		V	
3.491	+/-0.010	3.492	X		V	
Ø0.191	+0.005/-0.000	0.193	X		V	
3.123	+/-0.010	3.125	X		V	
1.975	+/-0.010	1.974	X		V	
Ø0.128	+0.005/-0.001	0.130	X		V	

<b>Measured by:</b> RB	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-10-18	<b>Date:</b> 10/10/19	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue      P/O D350-616-015	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	07.09.06	Dimensions updated per Dwg. Rev. F	KJ/JLM [Signature]	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

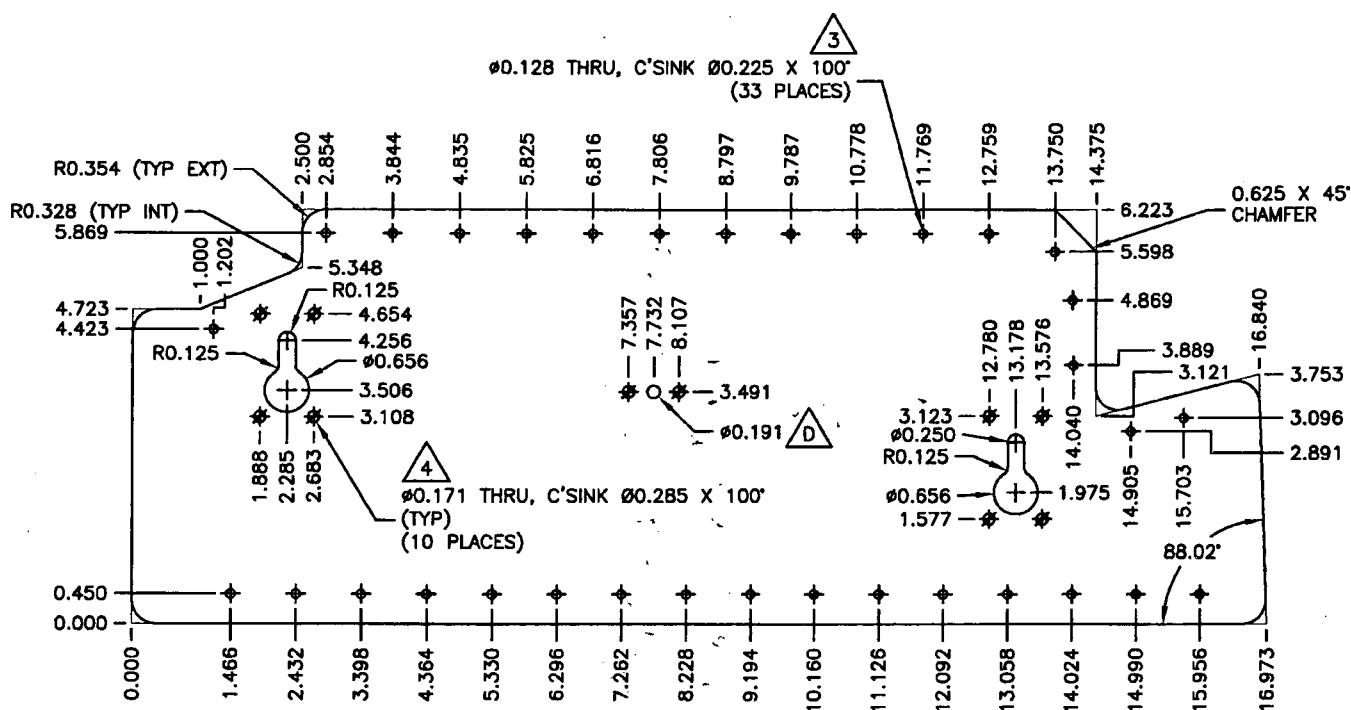
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**DART**SHOP COPY  
REV. 07.06.07UNCONTROLLED COPY  
SUBJECT: LITTER DECK PLATE, 350  
VIR  
WOP  
NO. 42814  
07.10.07

DESIGN KE	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JB	APPROVED H	DRAWING NO. D2344	REV. F SHEET 1 OF 1
DATE 07.06.07		TITLE LITTER DECK PLATE, 350	SCALE 1:3
A	95.01.14	NEW ISSUE	
B	95.02.09	MOVED KEY HOLES	
D	95.03.06	0.191 WAS 0.197	
E	98.06.19	0.063-0.071 THICK WAS 0.071 (TSR A371)	
F	07.06.07	C'SINK Ø0.285 WAS Ø0.308	

**D2344 LITTER DECK PLATE, 350**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063-0.071 THICK PER QQ-A-250/4  
(REF. DART SPEC. M2024T3S)
- 2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 3) COUNTERSINK HOLES MARKED  $\star$  TO Ø0.225 X 100
- 4) COUNTERSINK HOLES MARKED  $\star$  TO Ø0.285 X 100
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 8) IDENTIFY WITH DART P/N "D2344" USING WHITE PAINT MARKER

**RELEASED**

07.06.22

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## WORK ORDER CHANGES

E	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval	Approval
						Chief Eng / Prod Mgr	QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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